

Date: Thursday, 4/12/2007 8:51:26 AM
 User: Kim Johnston

Process Sheet

Split-

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LH STEP ACTUATOR ASSEMBLY
 Job Number : 31743
 Estimate Number : 12758
 P.O. Number :
 This Issue : 4/12/2007 S.O. No. :
 Prsht Rev. : NC Part Number : 41232 000 001 001
 First Issue : 1 / 1 Type : SMALL /MED FAB Drawing Number : 41232-000-001 REV A
 Previous Run : 31567 Material :
 Written By : Due Date : 5/10/2007 Qty: 4 Um: Each
 Checked & Approved By : 07.04.12
 Comment : Est Rev:A New Issue 07-02-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP41232-000-001

CHG 001 002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 AP0925ELBN BARBED ELBOW



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

BARBED ELBOW

Batch: M103727 ✓

4.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M102929 ✓

5.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M103914 ✓

7/5/4 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

AN423A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103688 ✓ ✓

7.0

MS3548993

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GROMMET

Batch: M103688 ✓ ✓

8.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M103962 ✓ ✓

9.0

MS24665151

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cotter Pin

Batch: M14526 ✓ ✓

10.0

MS203923C21

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pin

Batch: M11765 ✓ ✓

11.0

R 3400

plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total : 12.2000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch: M103351 ✓ ✓

12.0

41232 200 006 001

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

Batch: B30505 ✓

7/5/3 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Spacer (Step Actuator)

Batch: 1230503 ✓

14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Reducer Tee Assembly

Batch: B31779 ✓

15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring (Step Actuator)

Batch: N/A 7-05-03

16.0

41232 000 001 001

Step Actuator LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Actuator LH

Batch: B31746 ✓ (IX)

17.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring (Step Actuator)

BATCH: B30946 ✓

7/5/3 SQ (4)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Po 7/0/13 (1) c267/05/15 ⑩

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: _____

PPP Rev: _____

Per draft 7/5/15 SQ ①

7 added to kit 1 phase 124 K002 4CR 0545 m 104042 ✓
was part of assy left w/o - should be on pick w/o

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Le 07-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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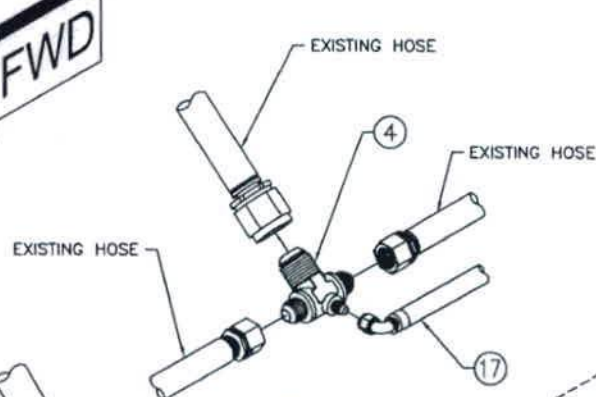
NOTE: Date & initial all entries

			REVISION		
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCORP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	isa04-1-1	1/14/04

A	1	1	17	PS4025ED00DF540A	HOSE						
	1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634					
	2	2	15	AN960JD416	WASHER						
	1	1	14	MS21042-L4	NUT						
	1	1	13	AN4-23A	BOLT						
	AR	AR	12	MIL-S-8802	SEALANT						
	1	1	11	MS35489-93	GROMMET						
	2	2	10	AN960JD416L	WASHER						
	1	1	9	MS24665-151	COTTER PIN						
	1	1	8	MS20392-3C21	PIN						
	2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309					
	1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)					
	3	3	5	41232-200-005-001	SPACER						
	1	1	4	41232-200-004-001	REDUCER TEE						
	1	1	3	41232-200-003-001	SPRING						
	1		2	41232-200-001-002	R/H ACTUATOR ASSY						
		1	1	41232-200-001-001	L/H ACTUATOR ASSY						
			-002	R/H INSTALLATION							
			-001	L/H INSTALLATION							
		-002	-001	END NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	
NO. REQ'D PER ASSY											
LIST OF MATERIAL											
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						CHECKED	D. MURPHY	5/20/02			
						STRESS					
						PROL					
						ENGR.					
				HEAT TREAT		Era Aviation, Inc.		DWG. NO. 41232-000-001 SHT 1 OF 2		REV. A	
				FINISH							
41232-1000				NEXT ASSEMBLY							

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WITHOUT NOTICE
WORK ORDER
NO. 31743

FWD



L/H STEP

L/H SKID TUBE

- 16 INSTALL ELBOW IN EXISTING SKID TUBE HOLE PREVIOUSLY USED FOR ELECTRICAL WIRE.
- 11
- 12

412-050-017-133 COVER (REF.)

EXISTING FLOAT BAG

ROUTE HOSE THROUGH FLOAT BAG ATTACHMENT ALONG SIDE OF EXISTING HOSE.

EXISTING HOSE

RETAINER (REF.)

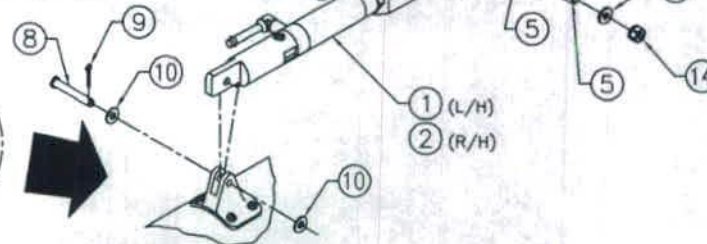
SCREW (REF.)

TORQUE SCREWS TO 12-15 INCH LBS.

BRACKET MUST BE INSTALLED AS SHOWN

FWD

VIEW LOOKING INBOARD



-001 L/H INSTALLATION (SHOWN)

-002 R/H INSTALLATION (OPPOSITE)

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STEP ACTUATOR INSTALLATION

DATE C 41232-000-001
SHT 2 OF 2

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